

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: *al* Date: *13/05/12*

Work Order: <u>94773</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D2933-1</u>				Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>		Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>	
NCR No. <u>13-2482</u>													
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data <input type="checkbox"/>	<u>13/4/1</u>	<u>100</u>	<u>4</u> <u>2</u>	<u>\$\phi\$ Slot is off-center by up to 0.003.</u> <u>Slot is up to 0.517 wide.</u>	<u>GP</u> <u>13/4/1</u>	<u>SCRAP 2.</u> <u>2 acceptable based on test fit</u> <u>139.02</u> <u>13-4-1</u>	<u>SL</u> <u>13-4-1</u>	<u>OK</u> <u>13/04/01</u>	<div style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;"> DAS 05 9-89 </div> <u>B.04.02</u>				
Equip/Tooling <input checked="" type="checkbox"/>													
Operator <input type="checkbox"/>													
Material <input type="checkbox"/>													
Setup <input type="checkbox"/>													
Other <input type="checkbox"/>													
Process <input type="checkbox"/>													
Supplier <input type="checkbox"/>													
Training <input type="checkbox"/>													
Unapproved <input type="checkbox"/>													
FAULT CATEGORY													
Landing Gear				General									
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced									
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure									
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld									
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled									
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Other									
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong										
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge										
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset											
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration											
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence											
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions											

Work Order ID 94773

94773

Page 2

December-20-12 8:49:11 AM

Item ID: D2933-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle LH In, 206
 Start Date: 12/19/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/11/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				2	2		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				2	2	13.4.4	
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:00								
	FINISH TIME: 12:30								

M125069 320°F 12:30 2X P m/ 13/04/08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____


Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Material <input type="checkbox"/>											
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
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Quality Control

2 of 13-4-8

2x ——— 80
134-9

13/4/10 

ME
13-4-9

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Picklist Print

December-20-12 8:49:11 AM

Page 1

Work Order ID: 94773

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	91.0000	1	4		12-13-27	

Location

Loc Qty

Loc Code

MAT040

91

91236

49

92595

12

93368

30

97239

4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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DART AEROSPACE LTD		Work Order:	94773
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

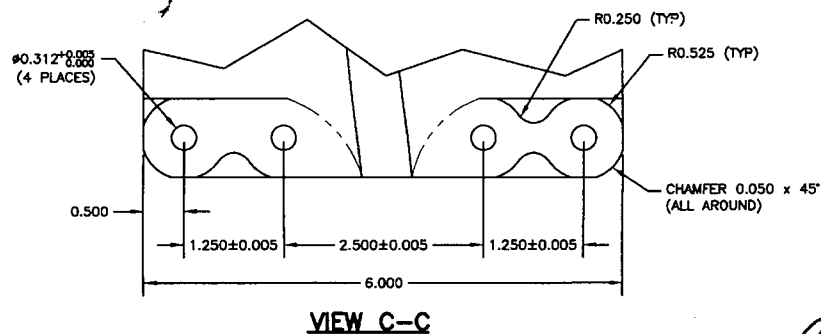
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		-122	-121	-120	-120	
B	0.100	0.140		-122	-121	-120	-120	
C	0.100	0.140		-120	-120	-120	-120	
D	0.210	0.230		-220	-220	-220	-220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.512	.512	.512	.512	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		-120	-120	-120	-120	
O	0.540	0.560		.549	.548	.549	.548	
P	0.490	0.510		.499	.499	.498	.498	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	2.490	2.490	
S	0.240	0.270		.251	.250	.250	.250	
T	0.100	0.180		-130	-130	-130	-130	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.136	1.136	1.136	1.136	
Y	1.565	1.585		1.576	1.576	1.576	1.576	
Z	0.178	0.198		-188	-188	-188	-188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by:	SL	Date:	13-3-27
Audited by:	OM	Date:	13/04/01
Prototype Approval:	N/A	Date:	N/A

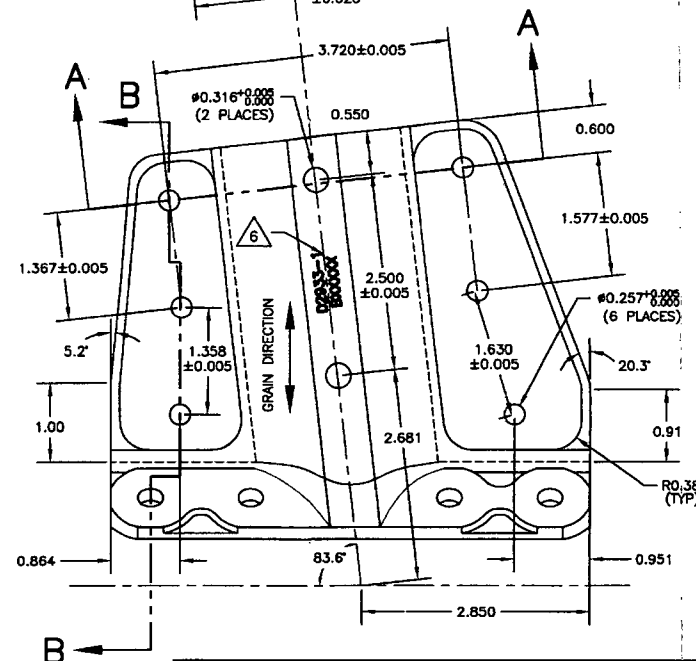
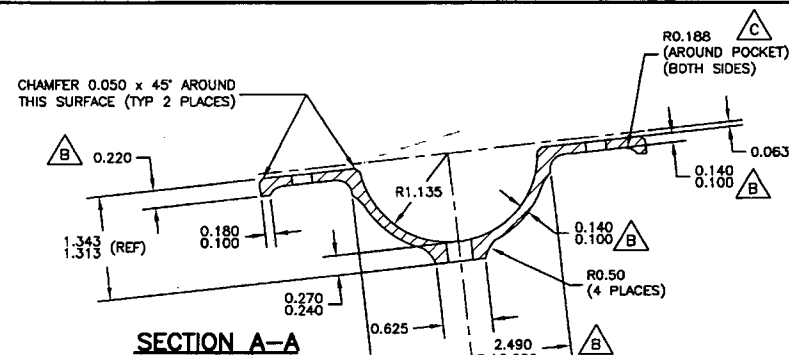
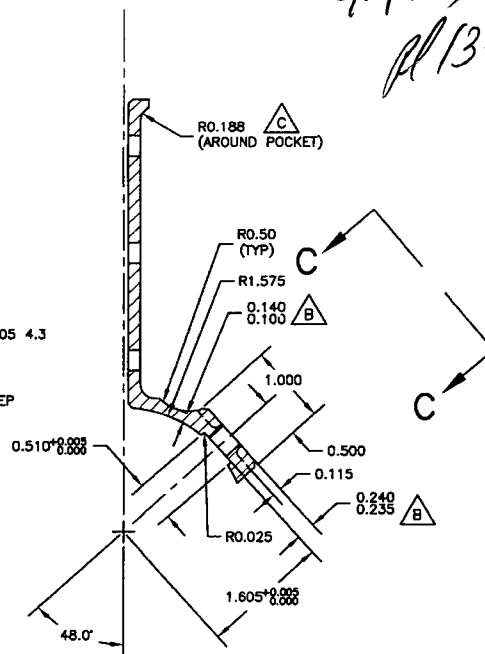
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		SCALE
		2:3

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DART DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO. D2933

REV. C

SHEET 1 OF 1